

Date: Monday, 2/27/2006 4:18:23 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, INBOARD, RS, 206
Job Number : 25981
Estimate Number : 10821
P.O. Number : N/A Part Number : D26662
This Issue : 2/27/2006 S.O. No. : N/A Drawing Number : D2666 REV. B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
Previous Run : 24850 Material : N/A
Written By : See comment below Due Date : 3/25/2006 Qty: 12 Um: Each
Checked & Approved By : 06-02-28
Comment : Est: C 00-11.01 Removed P/O for Powder Coat - in house processEC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
7075-T7351 2X6X6.25
Issue material from stock:
Cut Size 2.0 x 6.25 X 6.0
Grain Along Long 6.0 Length
Batch No: B 25342

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program batch number. 7
1-Inspect part number and batch number are programmed correctly. ✓
2-Fixturing W/O No. N/A
3-Fixturing Inspection last completed on N/A by SA
4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
7- Deburr SA / J.L 06/06/15

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet SA / J.L 06/06/15

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE SA / J.L 06/06/15

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:18:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 25981

Part Number: D26662

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 06/06/15 12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

H.M 06-06-19

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/06/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/06/20 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 471

06/06/20 (12)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/21 (12)

Job Completion



u 06.06.21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 25981
Description: 206 Saddle, Inboard, Right side	Part Number: D2666-2
Inspection Dwg: D2666 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.124	.124	.121	.122		
B	0.100	0.140		.122	.123	.122	.121		
C	0.100	0.140		.119	.123	.121	.119		
D	0.210	0.230		.220	.218	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.249		
G	5.990	6.010		6.001	6.001	6.001	6.002		
H	0.510	0.515		.514	.514	.514	.514		
I	1.674	1.684		1.679	1.679	1.679	1.679		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.238	.238	.238	.239		
N	0.100	0.140		.121	.119	.119	.120		
O	0.540	0.560		.548	.548	.548	.549		
P	0.490	0.510		.499	.496	.494	.498		
Q	3.609	3.619		3.613	3.613	3.613	3.613		
R	2.470	2.510		2.498	2.498	2.498	2.498		
S	0.240	0.270		.251	.251	.251	.251		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686	/	/	/	/		
V	1.125	1.145		1.132	1.131	1.131	1.131		
W	1.565	1.585	DT8695 A/B	/	/	/	/		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SA	3.1
Date: 06.06.14	06/06/15

Audited by: [Signature]	
Date: 06/06/15	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	

DART AEROSPACE LTD	Work Order:	25981
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.123	.122	.122	.121		
B	0.100	0.140		.123	.121	.122	.121		
C	0.100	0.140		.121	.120	.123	.124		
D	0.210	0.230		.218	.218	.219	.218		
E	1.245	1.255		1.250	1.250	1.250	1.249		
F	1.245	1.255		1.250	1.250	1.251	1.250		
G	5.990	6.010		6.002	6.003	6.002	6.002		
H	0.510	0.515		.514	.514	.514	.514		
I	1.674	1.684		1.679	1.678	1.679	1.679		
J	2.495	2.505		2.500	2.501	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.239	.239	.238	.239		
N	0.100	0.140		.120	.119	.119	.119		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.498	.500	.499	.499		
Q	3.609	3.619		3.614	3.613	3.614	3.614		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.252	.253	.255	.256		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686	/	/	/	/		
V	1.125	1.145		1.131	1.131	1.132	1.130		
W	1.565	1.585	DT8695 A/B	/	/	/	/		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SL
Date:	06/06/15

Audited by:	RM
Date:	06/06/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	

DART AEROSPACE LTD	Work Order: 25981
Description: 206 Saddle, Inboard, Right side	Part Number: D2666-2
Inspection Dwg: D2666 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.121	.122	.121	.123		
B	0.100	0.140		.120	.122	.120	.122		
C	0.100	0.140		.124	.121	.123	.123		
D	0.210	0.230		.215	.215	.217	.215		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.249		
G	5.990	6.010		6.003	6.003	6.002	6.002		
H	0.510	0.515		.514	.514	.514	.514		
I	1.674	1.684		1.679	1.679	1.678	1.679		
J	2.495	2.505		2.501	2.501	2.501	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.238	.238	.239	.239		
N	0.100	0.140		.114	.113	.113	.114		
O	0.540	0.560		.549	.550	.547	.548		
P	0.490	0.510		.498	.499	.499	.500		
Q	3.609	3.619		3.615	3.614	3.614	3.614		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.254	.254	.250	.251		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686	/	/	/	/		
V	1.125	1.145		1.129	1.131	1.131	1.130		
W	1.565	1.585	DT8695 A/B	/	/	/	/		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	06/06/15

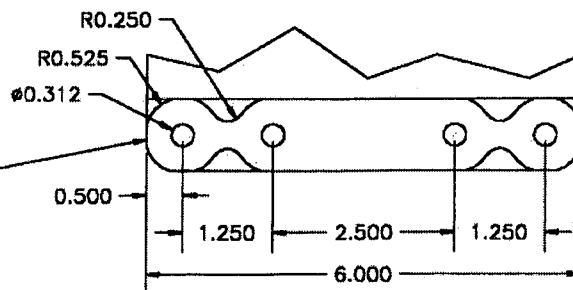
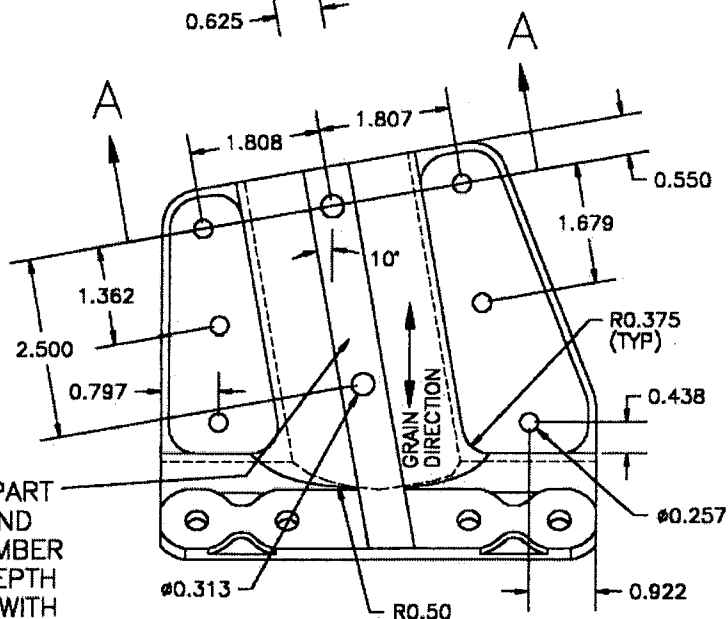
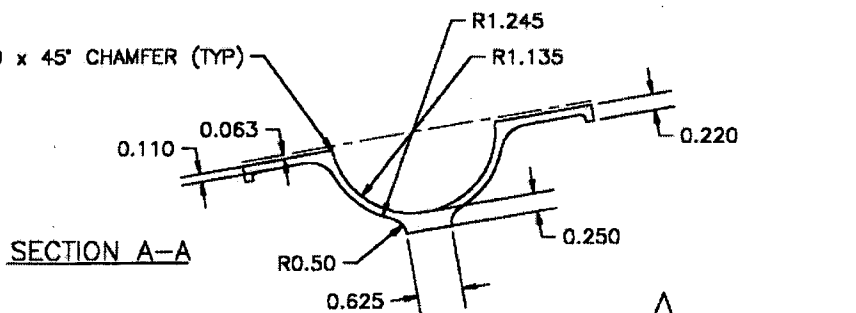
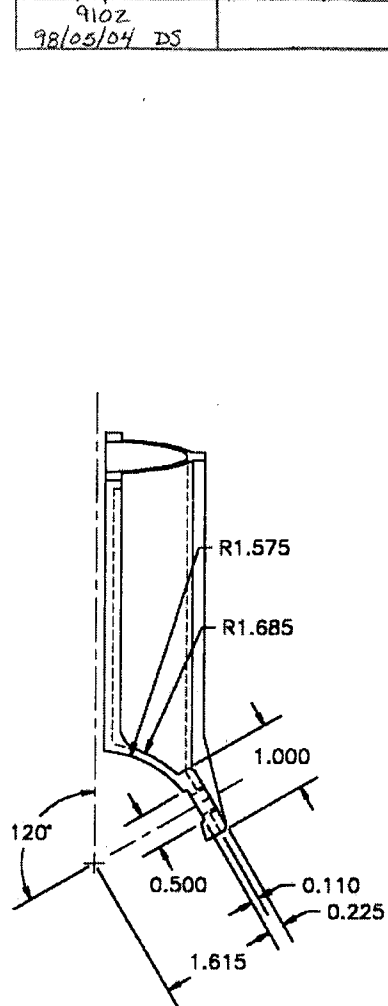
Audited by:	mf
Date:	06/06/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	



DESIGN <i>mev</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>mev</i>	APPROVED <i>KS</i>	DRAWING NO. D2666	REV. B SHEET 1 OF 1
DATE 97.07.11		TITLE SADDLE FWD INSIDE HIGH	SCALE 2:5
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	

EFFECTIVE	DEOs
9095 17/11/06 DS	9122 98/12/14
9102 98/03/04 DS	



ENGRAVE PART-
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

RELEASED
97/07/16 DS

ECN 008

MATERIAL: ~~7075-T651-OR~~ 7075-T7351 (QQ-A-250/12)

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2

NOTE: D2666-1 SHOWN (D2666-2 IS OPPOSITE)
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
NOTED
RETURN TO
ENGINEERING

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WORK ORDER
NO. 2598